

Date: Friday, 01/08/2008 3:32:01 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: END FITTING ASSY RH
Job Number	: 40963		
Estimate Number	: 13343		
P.O. Number	:	Part Number	: D3763044
This Issue	: 01/08/2008 S.O. No. :	Drawing Number	: D3763 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 40962	Material	:
Written By	:	Due Date	: 21/08/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>JUL 08.08.05</u>		
Comment	: Est Rev:A 08-05-20 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D37631	End Fitting
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

End Fitting

batch: 340994 ✓ SP 08.08.13 (8X)

3.0	D37636	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube

batch: 340706 ✓ SP 08.08.13 (4X)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-make a 0.063" chamfer on D3763-1 fitting before ass'y SP 08.08.13

2-assemble and tack weld as per dwg D3763 using locating pin DT9014 SP 08.08.13

*****look at dwg before assembling parts (RH) *****

*****remove pin before welding*****

3-weld as per dwg D3763, QSI004

Alum. rod Batch: 108037 SP 08.08.13 (4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END FITTING ASSY RH

Job Number: 40963

Part Number: D3763044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-08-13

D

08-08-013

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-08-14



7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: GA TFE

08-08-14

8.0

QC21

FINAL INSPECTION/W/O RELEASE



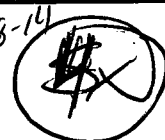
Comment: FINAL INSPECTION/W/O RELEASE

4

Job Completion



MF 08-08-14



→ 6.1 Chemical conversion cost

RD/M/08/08/14

→ 6.2 QC3. => JD

08-08-14

X5

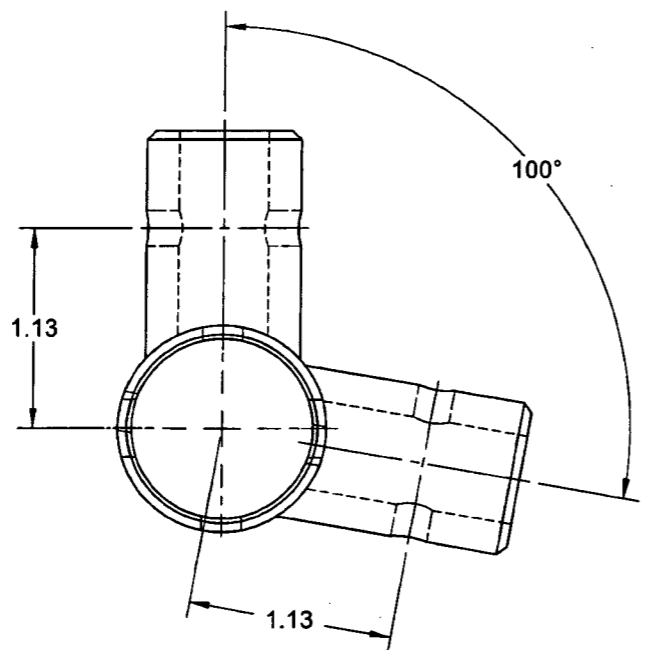
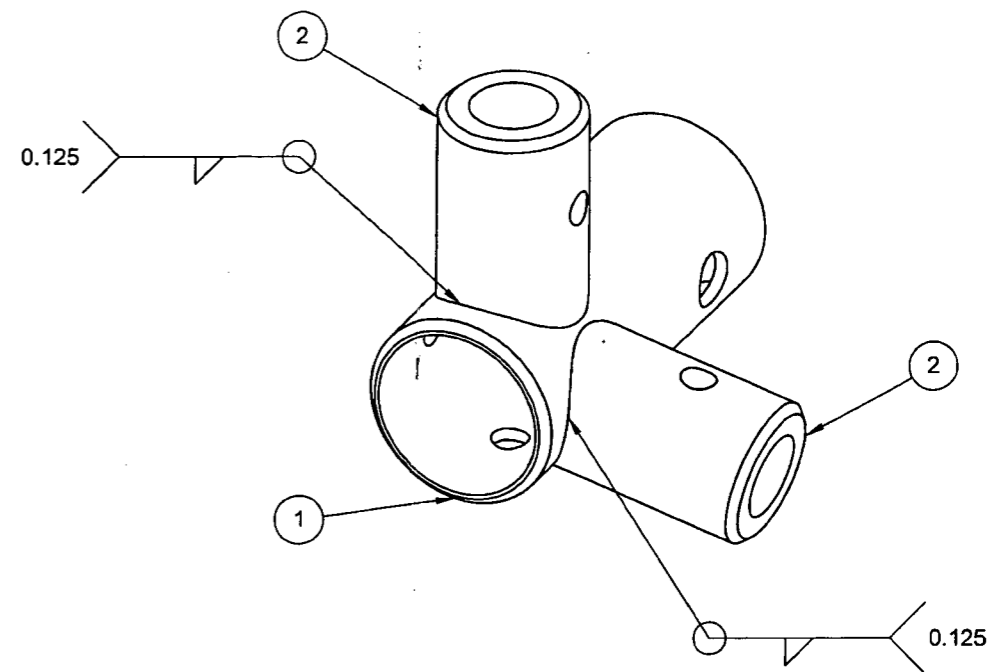
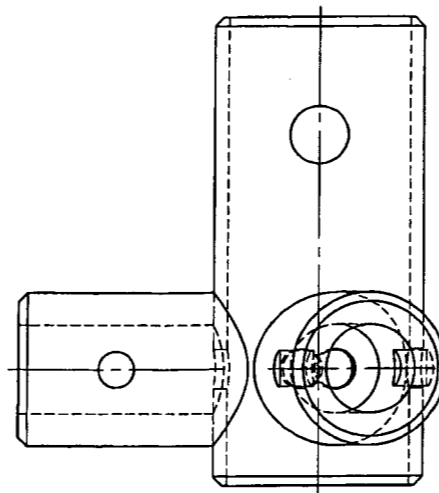
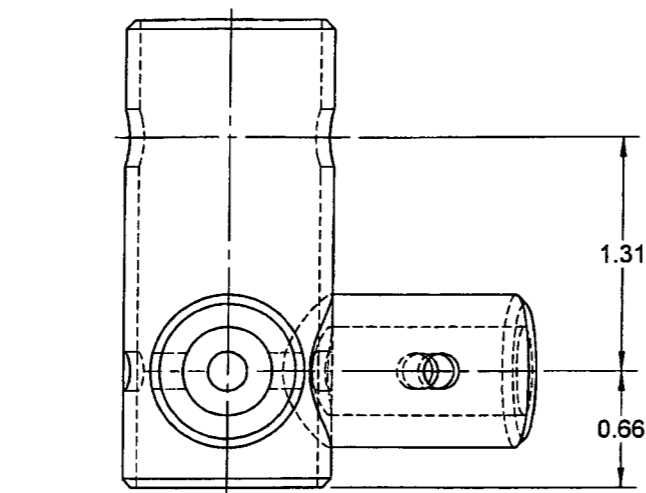
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

D3763-044 END FITTING ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

RELEASED
08.07.10
WORK ORDER
NO. 160903

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PL	DRAWING NO.	REV. B
MFG. APPR.	MD	D3763	SHEET 3 OF 9
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	END FITTING	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	